

56724/07

Date: Wednesday, 7/11/2007 3:05:56 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 33511		
Estimate Number	: 12559		
P.O. Number	: N/A	Part Number	: D32381
This Issue	: 7/11/2007	Drawing Number	: D3238 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 7/23/2007
Checked & Approved By	: <u>                    </u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 06-10-20 EC Est Rev:B Now on Waterjet 07-01-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 0.0126 sf(s)/Unit Total: 0.2520 sf(s)

2024-T3 .080 sheet

batch: ~~M104921~~ M104921

IB 07-07-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3238 (cut BLANK File) 2x

Dwg Rev: C

Prog Rev: C

IB 07-07-19

2048

2-Deburr if necessary

FF 07-07-23 (28)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-07-23

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

FF 07/07/23

(28)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-A 07/07/23

(28X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/01/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 7/11/2007 3:05:56 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 33511

Part Number: D32381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/7/23 59

28x

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08

Comment: FINAL INSPECTION/W/O RELEASE

7/10/24

Job Completion



u 8-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

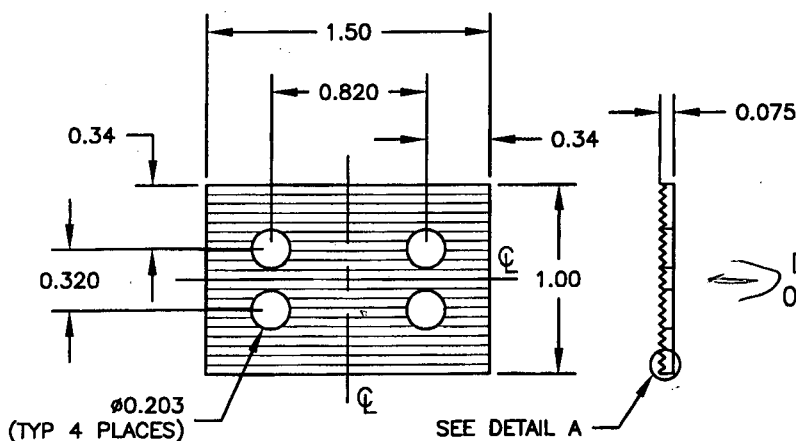
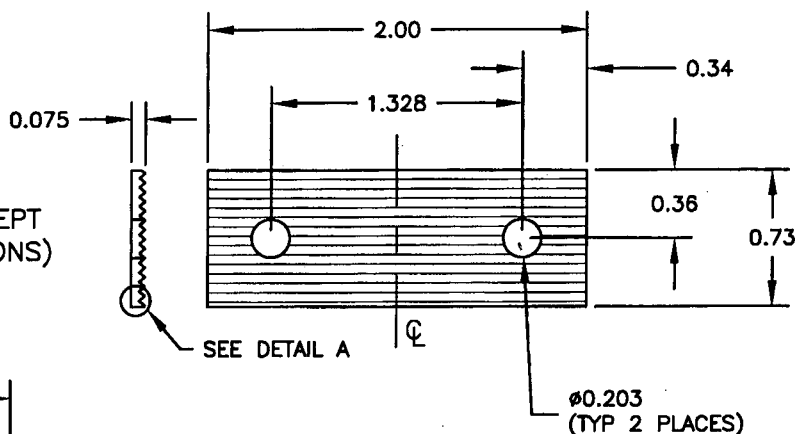
**NOTE:** Date & initial all entries

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

**RELEASED**

07.02.20 #

**D3238-1 PLATE (SHOWN)**D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)**NOTES:**

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
ORALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) SEE SHEET 3 FOR DETAIL A

7) PARTS ARE SYMMETRIC ABOUT C

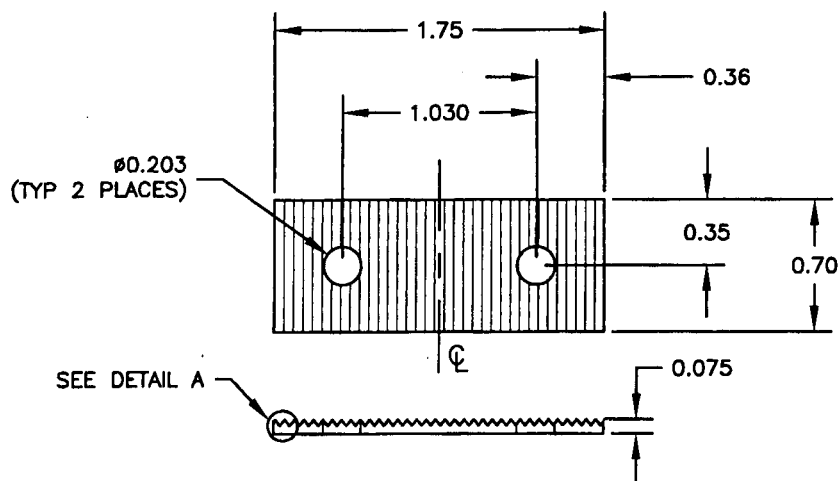
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WITH NOTICE  
WORK ORDER  
NO. 33511

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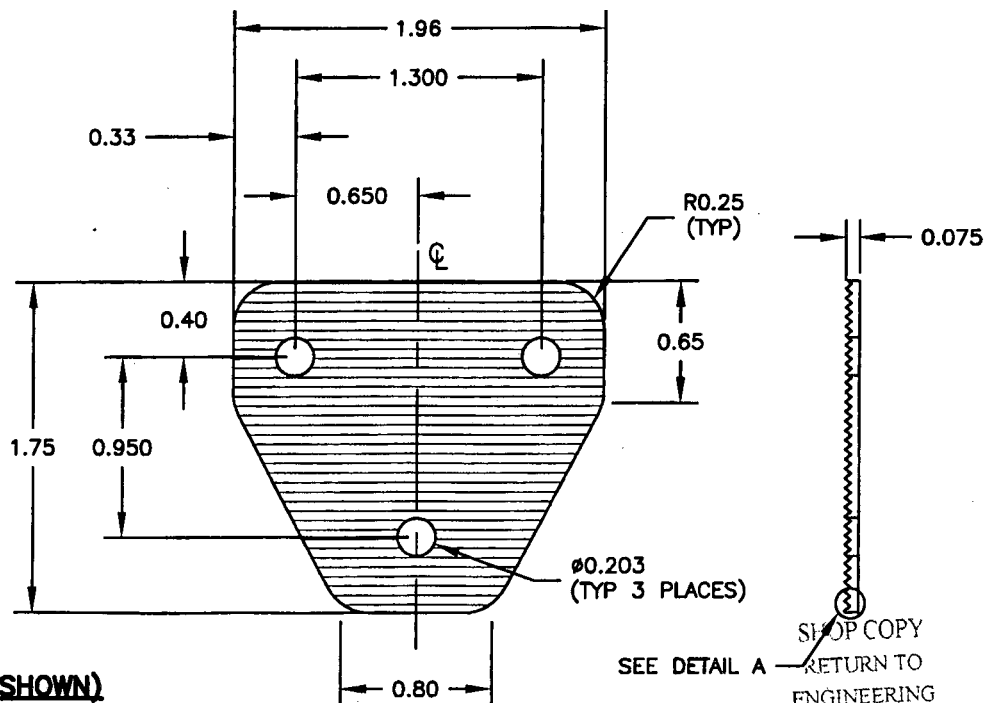


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



RELEASED  
07.02.20 #

**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

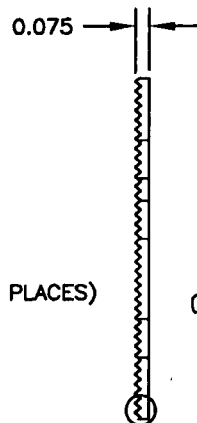
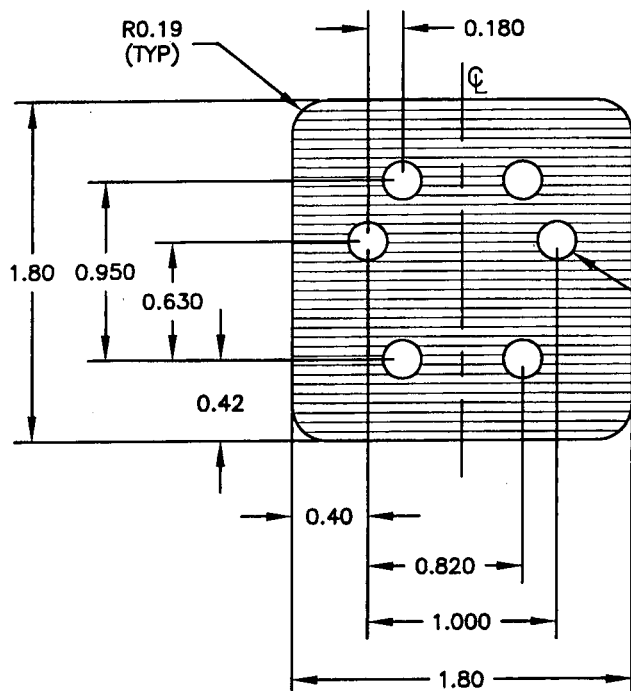
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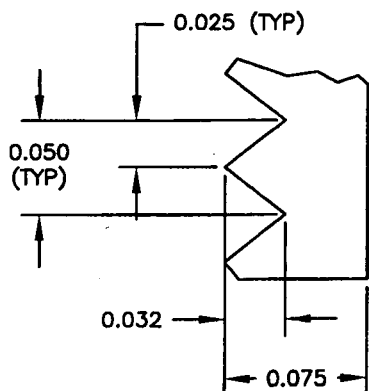
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



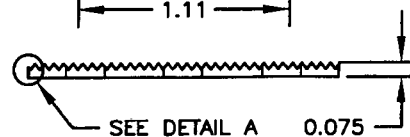
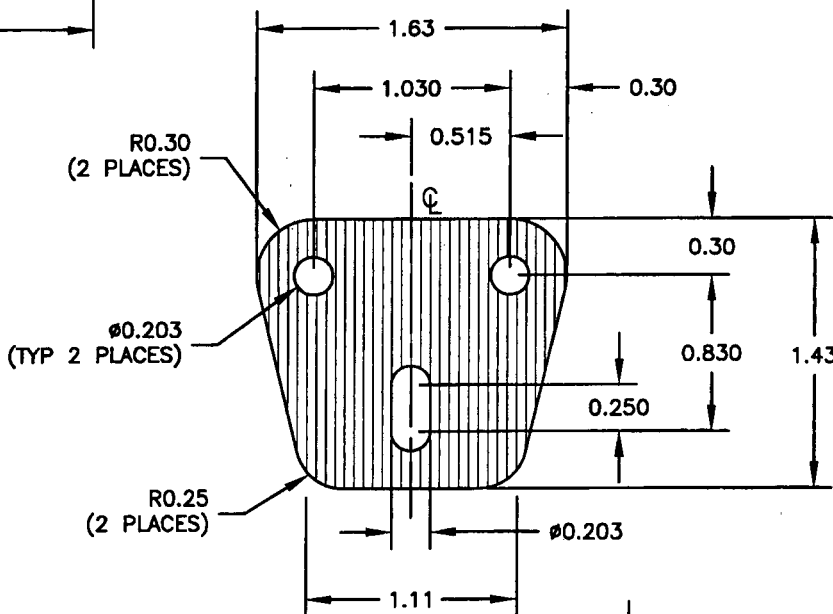
RELEASED  
07.02.20 #

**D3238-23 PLATE (SHOWN)**  
D3238-33 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



**DETAIL A**  
RIDGE DETAIL (VIEW MAY BE ROTATED)  
SCALE 10:1



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RETURN TO  
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**D3238-25 PLATE (SHOWN)**  
D3238-35 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

DIRECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
33511

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DART AEROSPACE LTD		Work Order: 33511
Description: PLATE		Part Number: D 3238-1
Inspection Dwg:	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1) 2.00	+/- .030	2.00	*			
.73	+/- .030	.73	*			
.34	+/- .030	.34	*			
.36	+/- .030	.36	*			
1.328	+/- .010	1.329	*			
Ø .203	+0.005 - .001	.204	*			
.075	+/- .010	.081	*			
<del>1.50</del>	<del>+/- .030</del>	<del>1.50</del>	<del>*</del>			
<del>.800</del>	<del>+/- .010</del>	<del>.823</del>	<del>*</del>			
<del>.34</del>	<del>+/- .030</del>	<del>.34</del>	<del>*</del>			
<del>1.00</del>	<del>+/- .030</del>	<del>1.00</del>	<del>*</del>			
<del>.320</del>	<del>+/- .010</del>	<del>.322</del>	<del>*</del>			
<del>.34</del>	<del>+/- .030</del>	<del>.34</del>	<del>*</del>			
<del>.075</del>	<del>+/- .010</del>	<del>.081</del>	<del>*</del>			
<del>Ø .203</del>	<del>+0.005 - .001</del>	<del>.203</del>	<del>*</del>			

JH/MS

Measured by: FB	Audited by: En	Prototype Approval: u/a
Date: 07-07-23	Date: 07/07/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	